

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 1

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-09-05 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-041	G								

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

record fwd angle:

89.6° DGL 0.00

OCT 29 2014

DAS
00
S-89

MLJ

Doc.Control -USB or Paperwork

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 2

Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 5/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B)								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

DGC 14-9-29 DGC 14-9-10

PTO

DGC 14-9-29

BB 14-09-30

DQA: AW Date: 14/12/08QA Closed: 2109 Date: 14/12/14

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>124013</u> Part No. <u>D350-636-011</u> NCR No. <u>14-4342</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input checked="" type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14-9-18	110	1	Employee noticed while Test Fitting Blade fitting I-Beam was out of alignment in D2600-3-Beam. RC; Tube Rolled in Rollers while bending.	AW	Scrap 1 D2600-3-Beam B1203609 + Replace with D2600-3-Beam B. \$88.43	AW DAS 29 9-89	AW DAS 29 9-89	AW DAS 29 9-89
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process	X									
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input checked="" type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	--	--

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 3

Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: M129399

9-Grind welds flush as per Dwg D2750

786140930

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo 0.00

Quality Control

① 14-10-01DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo 0.00

Quality Control

① 14-10-01DAS
9
9-89

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 4

Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop

NS2

Start Date: 9/05/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/05/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

1 / 14-10-1 JG

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

① / 14-10-1 JH

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 5

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole using un-bit to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>129457</u> exp. date: <u>11-11-20</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M129285</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

14-10-2

78E14-10-02

14-10-1

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 6

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								
	12-Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control		0.00							
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								

19/10/08

14/10/02

14-10-08

Work Order ID 124013

124013

September-05-14 1:41:28 PM

Page 7

Item ID: D350-636-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.
 Start Date: 9/05/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				11	f	11	10/08
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
200									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 128975								CR 14/10/17
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 130531								
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								x1641 f 14/10/20

DAS
15
9-89

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 8

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

230

HandFinish

HandFinishing

0.00

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

2-Inspect for Foreign Objects

3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11130227

EXP DATE: 15108

4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11129305 RTU 398 1361K 11125792 exp 15108

5- Coat all exposed fasteners with "LPS Procyon" batch: 11122900

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

DAS
38
9-89

14-10-22

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 9

Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop

NS2

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				IX		DAS 26 9-89	OCT 28 2014
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00						DAS QC 9-89	OCT 29 2014
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								
270		0.00							
270									
Packaging	Packaging	0.00							
Packaging	Memo	0.00						DAS QC 9-89	OCT 30 2014
Packaging	Package as per PPP D350-636-011								

Work Order ID 124013

September-05-14 1:41:28 PM

124013

Page 10

Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

14/11/30

ME

14-10-30

Picklist Print

September-05-14 1:41:31 PM

Page 1

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD
 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No			230	Each	121.0000	8	8			

D3492-1

Plug

Location

Loc Qty

Loc Code

FP001

121

B124026

111578

2

x 2

114879

7

119646

2

120519

50

122460

60

x 6

D3492-3

Manufactured No

230

Each

142.0000

8

8

D3492-3

Plug

Location

Loc Qty

Loc Code

FP001

142

B124023

104853

24

x 6

107331

1

112739

1

115807

6

118977

10

123464

100

Picklist Print

September-05-14 1:41:31 PM

Page 2

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

383.0000

8

8

NAS1611-010

O-RING

all 11/10/14

Location

Loc Qty

Loc Code

FP001

383

m126988

3

m127813

4

m128375

10

m129198

44

m129405

82

m129523

240

VG

NAS1149D0863J

Purchased

No

250

Each

795.0000

2

2

NAS1149D0863J

Washer

DAS
26
9-89

OCT 29 2014

Location

Loc Qty

Loc Code

ST276

595

118078

2

125268

586

125484

7

2X

ST2776

200

125635

200

D2744

Manufactured

No

110

Each

53.0000

1

1

D2744

Cap

BE14-09-30

Location

Loc Qty

Loc Code

LG001

53

113128

52

115440

1

Picklist Print

September-05-14 1:41:31 PM

Page 3

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

1.0000

1

1

D2600-3-BENT

Extrusion Bent

LH

124662

**

DGC 14-9-10
14-9-29

Location

Loc Qty

Loc Code

LG002

1

1

①

119600

D2743

Manufactured No

160

Each

192.0000

8

8

D2743

Crossbolt Spacer

**

BE14-10-02

Location

Loc Qty

Loc Code

LG001

192

109799

1

112729

59

119609

58

120481

74

8 5

3

D2739

Manufactured No

160

Each

13.0000

1

1

D2739

350 I Beam

**

Location

Loc Qty

Loc Code

LG

10

123536

10

LG002

124522

3

117245

2

117803

1

①

14-10-1

D3490-3

Manufactured No

160

Each

72.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE14-10-02

Location

Loc Qty

Loc Code

LG

72

122458

22

122751

50

4

September-05-14 1:41:31 PM

Shop Packet Print

Page 3

Picklist Print

September-05-14 1:41:31 PM

Page 4

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

100.0000

4

4

D3490-1

Cross Bolt Spacer

BE 14-10-02

Location

Loc Qty

Loc Code

LG

85

122457

85

LG001

15

112737

1

116358

14

Each

258.0000

38

ALS4-1032-225

AELS8-1032-225

Purchased

No

AI S4-1032-225

✓ ALS4-1032-225

Rivnut

lll 14/10/20

Location

Loc Qty

Loc Code

FG

30

M127028

30

M130565

✓38

ST267

228

M127028

10

M127092

26

M128179

192

D3793-3

Manufactured No

230

Each

8.0000

1

1

D3793-3

Wearplate Aft

lll 14/10/21

Location

Loc Qty

Loc Code

FP001

1

104212

1

B123333

✓1

FP002

7

120141

7

Picklist Print

September-05-14 1:41:31 PM

Page 5

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

73.0000

1

1

AN8C35A

Bolt

all 10/10/21

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

69

m126293

29

m127823

1

m130114

39

✓

D3793-1

Manufactured

No

230

Each

11.0000

1

1

D3793-1

Wearplate Fwd

all 10/10/21

Location

Loc Qty

Loc Code

FP002

11

112741

2

120212

8

92382

1

13123366

✓

D3488-041

Manufactured

No

230

Each

7.0000

1

1

D3488-041

Blade Fitting LH

all 10/10/21

Location

Loc Qty

Loc Code

FP001

7

116834

6

88255

1

✓

Picklist Print

September-05-14 1:41:31 PM

Page 6

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

11.0000

1

1

D3794-3

Gasket Aft

lll 14/10/21

Location

Loc Qty

Loc Code

FP001

11

B124948

xl

111457

8

122529

2

92658

1

AN6C44A

Purchased

No

230

Each

45.0000

4

4

AN6C44A

Bolt

lll 14/10/21

Location

Loc Qty

Loc Code

FG

2

103964

2

M1130665

xl

ST333

43

m128319

2

m128700

1

m129199

40

MS21083C8

Purchased

No

230

Each

64.0000

1

1

MS21083C8

Nut

lll 14/10/21

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

xl

Picklist Print

September-05-14 1:41:31 PM

Page 7

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

15.0000

1

1

D3536-25

Gasket Center

**

B125637 (1/2) all 11/10/21

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

9

110652

1

123300

7

93696

1

D3631-1

Manufactured No

230

Each

126.0000

8

8

D3631-1

Washer

**

all 11/10/21

Location

Loc Qty

Loc Code

FP001

126

110258

16

119553

10

123452

100

D3791-1

Manufactured No

230

Each

6.0000

1

1

D3791-1

Wearpad

**

all 11/10/21

Location

Loc Qty

Loc Code

FP001

1

92689

1

FP002

5

118942

5

B120343

Picklist Print

September-05-14 1:41:31 PM

Page 8

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

3,653.000

38

38

NAS1149C0332R

WASHER

all 10/10/21

Location

Loc Qty

Loc Code

CA

83

m129682

83

ST278

3570

122063

41

125654

609

m126319

61

m127306

2500

m127410

75

m127831

26

m128591

75

m129499

183

X30

D2745

Manufactured

No

230

Each

145.0000

8

8

D2745

Bushing

all 10/10/21

Location

Loc Qty

Loc Code

ST010

145

107336

4

113176

2

117099

7

119572

51

122643

73

90323

2

93336

6

X 8

Picklist Print

September-05-14 1:41:31 PM

Page 9

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased No

230 Each 140.0000 34 34

AN3C5A

Bolt

**

lll 11/10/21

Location

Loc Qty

Loc Code

FG

5

122800

5

M130358

x34

ST350

135

M128911

27

M128973

10

M129913

98

D3537-1

Manufactured No

230 Each 93.0000 3 3

D3537-1

Wearpad

**

lll 11/10/21

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

75

113839

4

120644

52

120645

18

93945

1

B124485

x3

NAS1149C0832R

Purchased No

230 Each 258.0000 1 1

NAS1149C0832R

Washer

**

lll 11/10/21

Location

Loc Qty

Loc Code

ST277

258

m114915

108

m125807

150

x1

Picklist Print

September-05-14 1:41:31 PM

Page 10

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

1,058.000

4

4

AN3C6A

Bolt

ll 14/10/21

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

1048

m125709

52

m128769

996

x4

NAS1611-013

Purchased

No

230

Each

140.0000

8

8

NAS1611-013

O-RING

ll 14/10/21

Location

Loc Qty

Loc Code

FP001

140

m128375

72

m129430

68

M130358

x8

D3535-25

Manufactured

No

230

Each

24.0000

1

1

D3535-25

Wearplate Center

ll 14/10/21

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

22

110744

1

123415

20

93278

1

x1

Picklist Print

September-05-14 1:41:31 PM

Page 11

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

2.0000

1

1

D3794-1

Gasket Fwd

all 10/10/20

Location

Loc Qty

Loc Code

FP001

2

13124082

109207

1

x1

93381

1

MS21043-6

Purchased

No

230

Each

58.0000

4

4

MS21043-6

NUT

all 10/10/20

Location

Loc Qty

Loc Code

FG

20

11130325

103693

20

x1

ST306

38

m127255

6

m127813

32

D3493-1

Manufactured

No

250

Each

139.0000

2

2

D3493-1

Washer

DAS
26
9-89

OCT 29 2014

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

129

109105

129

2x

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Picklist Print

September-05-14 1:41:31 PM

Page 12

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

64.0000

2

2

MS21083C8

Nut

**

m/30358

DAS
26
9-89

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

OCT 2 9 2014

DAS
03
9-89

AN8C21A

Purchased

No

250

Each

62.0000

2

2

AN8C21A

Bolt

**

OCT 2 9 2014

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

60

m127061

2

m127823

3

m129888

55

2x

NAS1515H3L

Purchased

No

230

Each

293.0000

4

4

***NAS1515H3I ***

Washer

**

14/10/2014

Location

Loc Qty

Loc Code

FG

40

102472

40

ST273

253

m127831

136

m128976

117

vd

Picklist Print

September-05-14 1:41:31 PM

Page 13

Work Order ID: 124013

124013

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

48.0000

1

1

D2741

Blade

DAS
26
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

10

100664

5

113640

2

115522

3

ST538

38

118387

38

/K

D3532-1

Manufactured No

250

Each

34.0000

2

2

D3532-1

Spacer

DAS
26
9-89

OCT 2 9 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

ST048

34

115855

3

117198

3

122723

21

123513

7

2x

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C818L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/2/3-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL "F" SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 124013 MLS
14-09-05

RELEASED
2013-08-13
ND

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C818; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

TITLE

350 SKIDTUBE ASSEMBLY

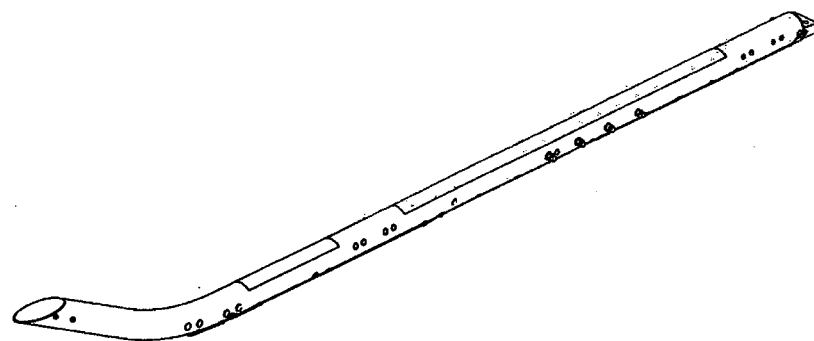
COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

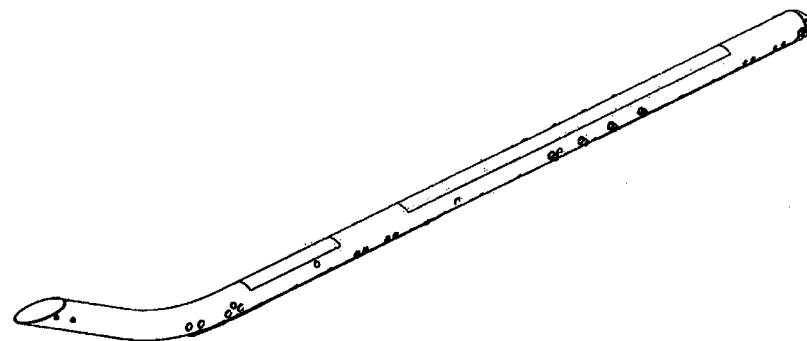
REV. G
SHEET 1 OF 11

SCALE

NTS



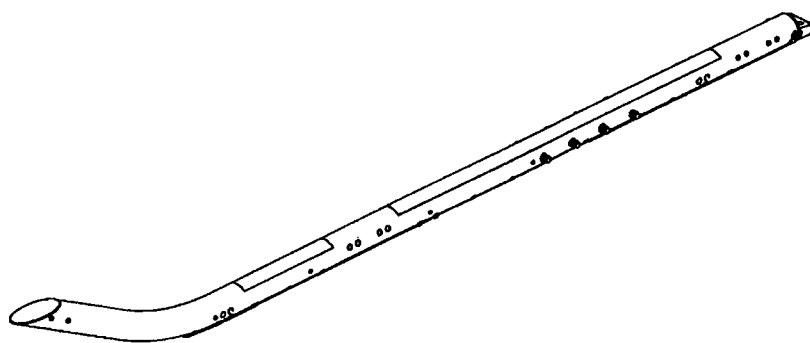
D2750-041 350 SKIDTUBE ASSEMBLY, LH



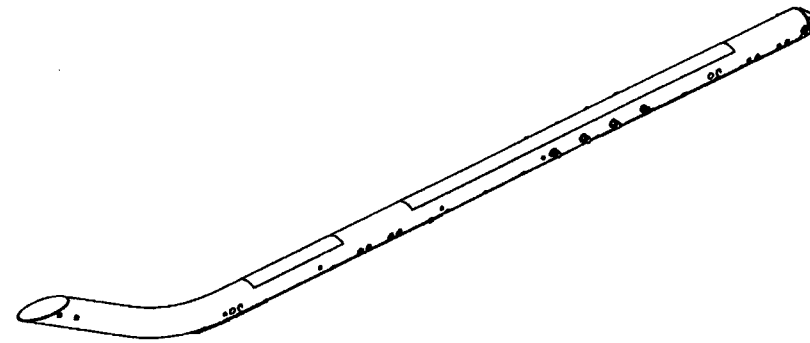
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MP

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1984 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR FORM OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	



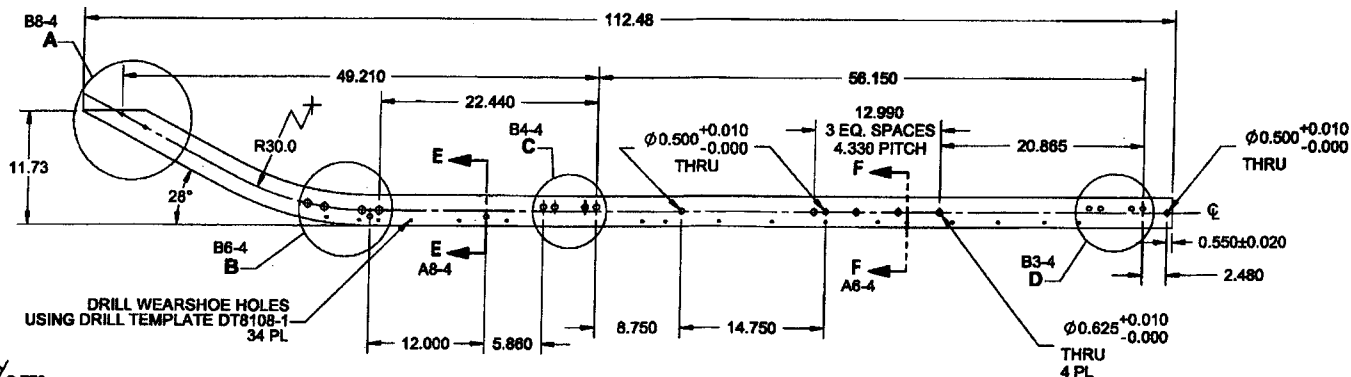
D2750-043 350 SKIDTUBE ASSEMBLY, LH



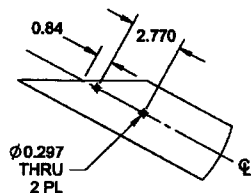
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
WPD

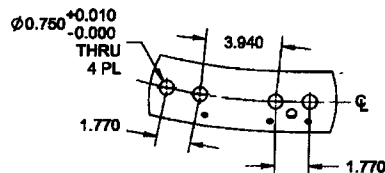
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1996 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



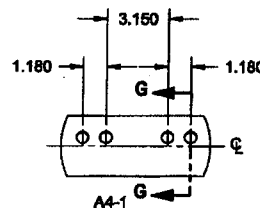
D2750-1 LH SKIDTUBE



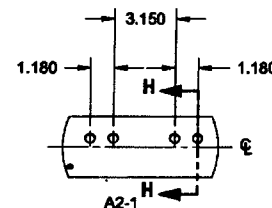
DETAIL A
SCALE 2X



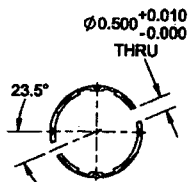
DETAIL B
SCALE 2X



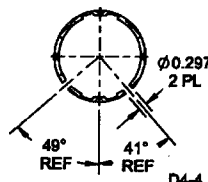
DETAIL C
SCALE 2X



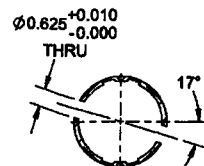
DETAIL D
SCALE 2X



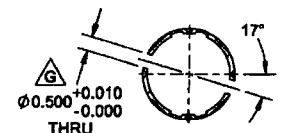
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

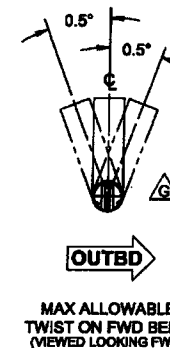
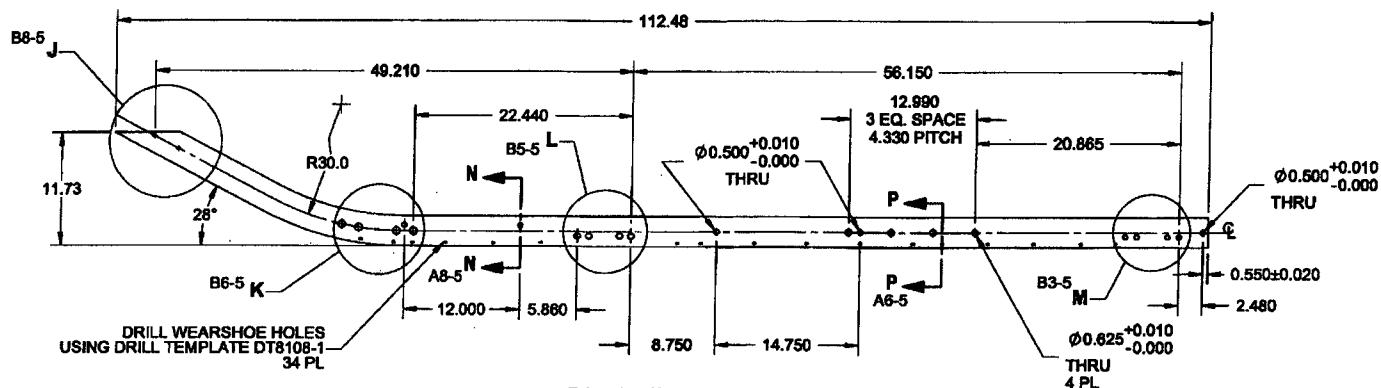
DESIGN	MM
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	13.07.11

DART AEROSPACE USA, INC.
KENT, WA

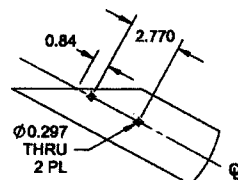
DRAWING NO. **D2750**
TITLE **350 SKIDTUBE ASSEMBLY**
SCALE **NTS**

REVISIONS
REV. G
SHEET 4 OF 11

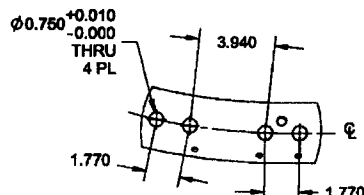
RELEASED
2013-08-13



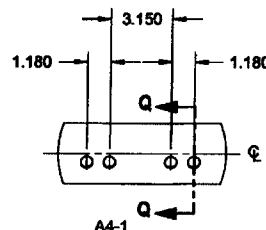
D2750-2 RH SKIDTUBE



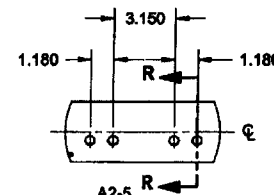
DETAIL J
SCALE 2X



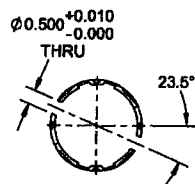
DETAIL K
SCALE 2X



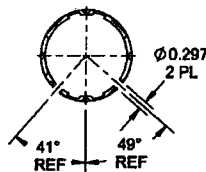
DETAIL L
SCALE 2X



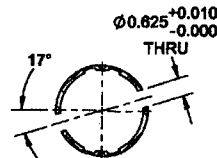
DETAIL M
SCALE 2X



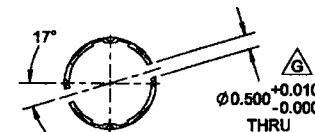
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

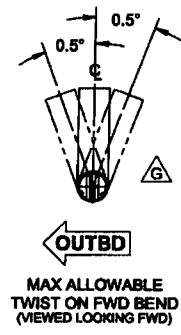
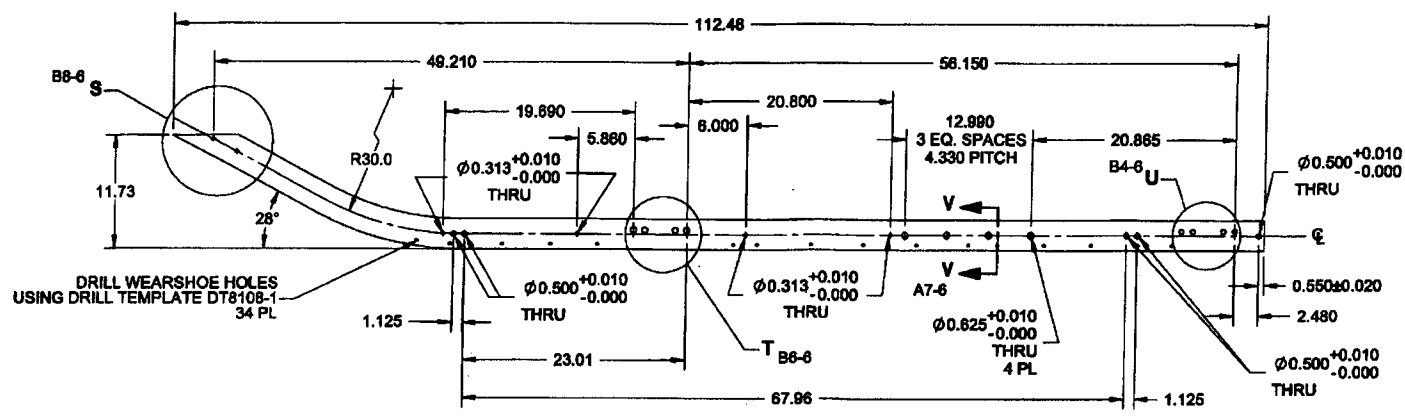


SECTION R-R
SCALE 3X, 4 PL

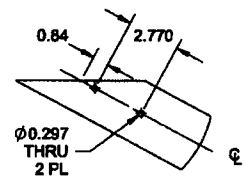
RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small> COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

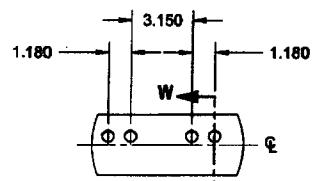
8 7 6 5 4 3 2 1



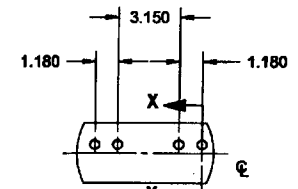
D2750-3 LH SKIDTUBE



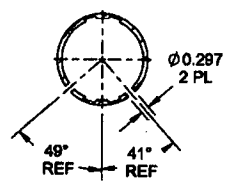
DETAIL S
D8-6
SCALE 2X



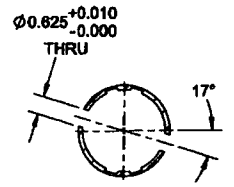
DETAIL T
C5-6
SCALE 2X



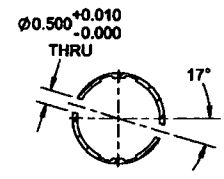
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL

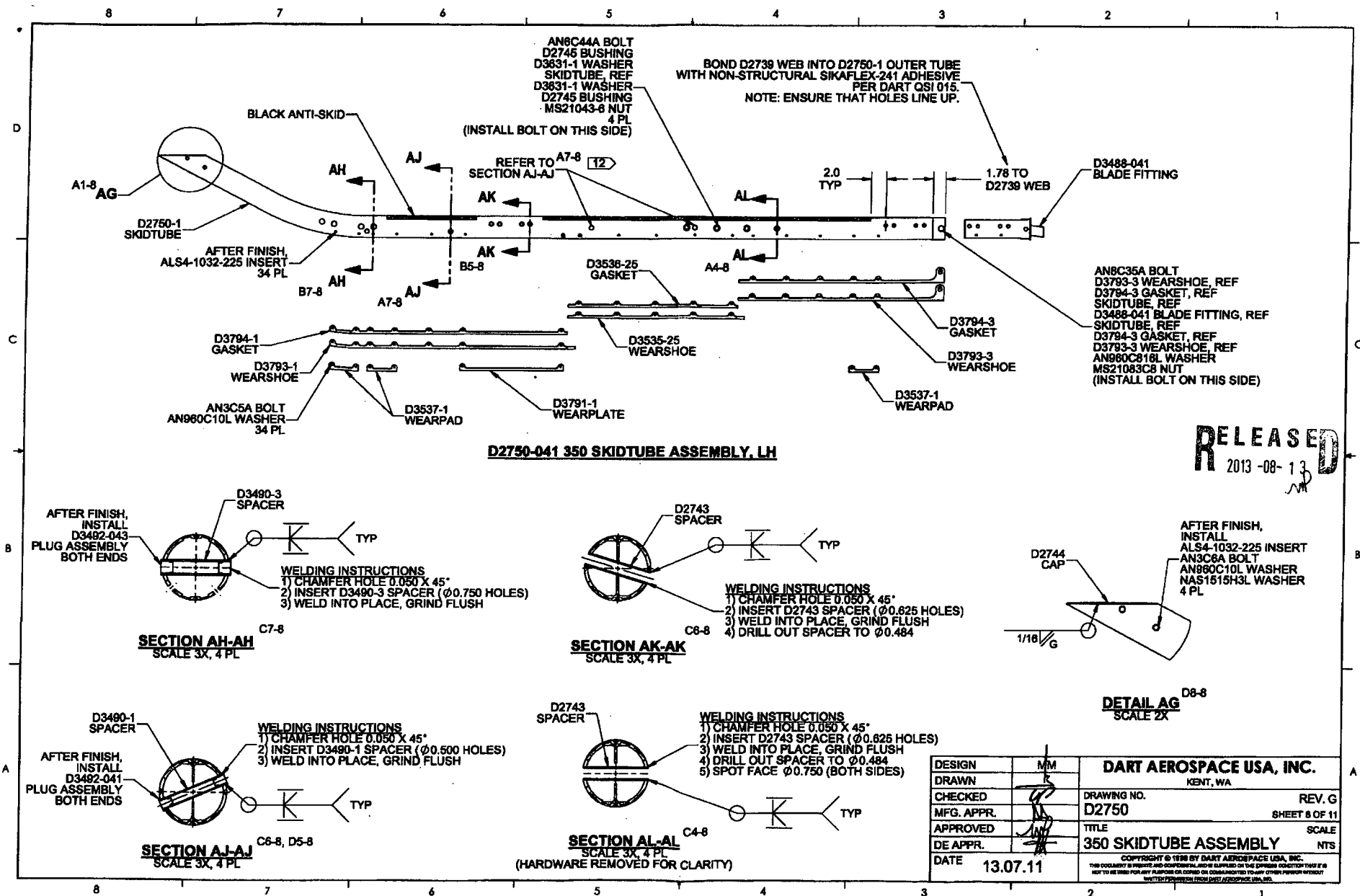


SECTION X-X
B4-6
SCALE 3X, 4 PL

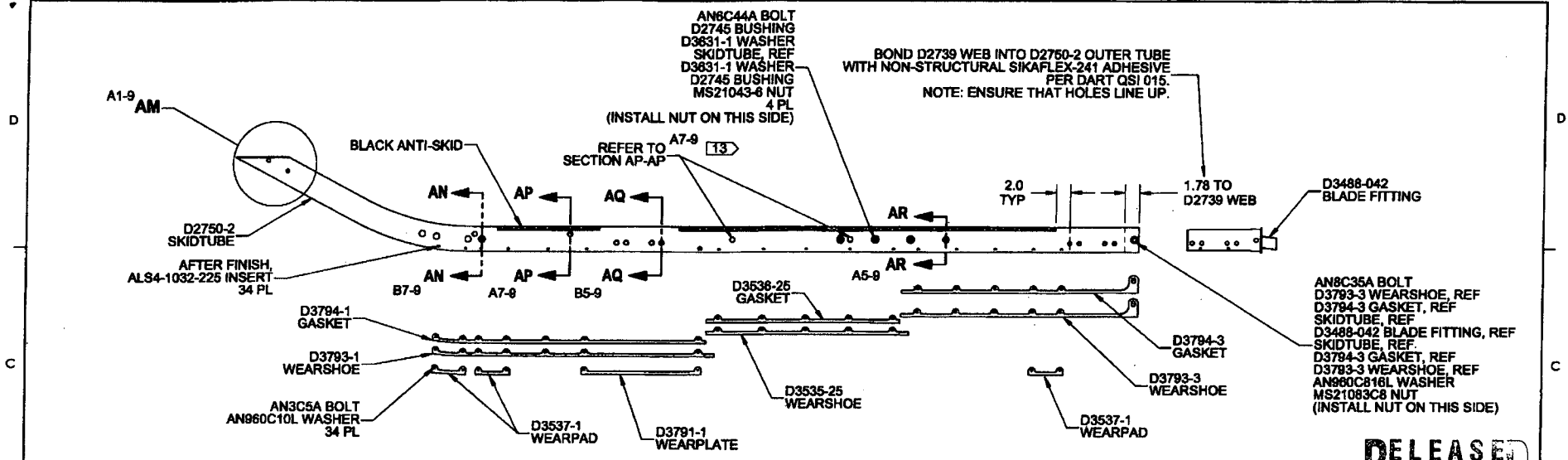
RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small> COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PREPARED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

8 7 6 5 4 3 2 1

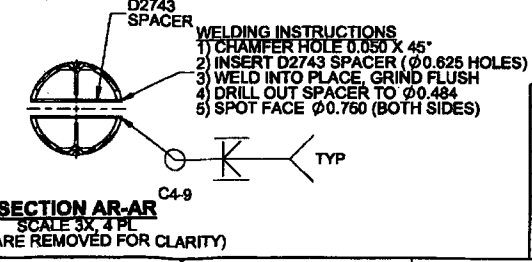
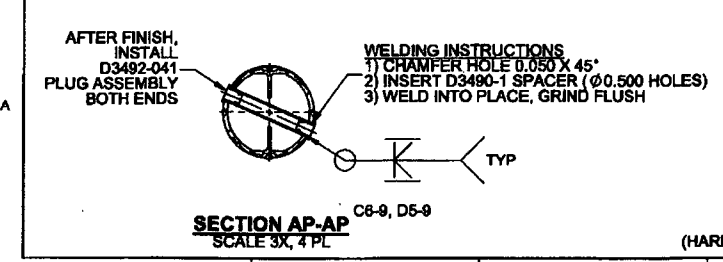
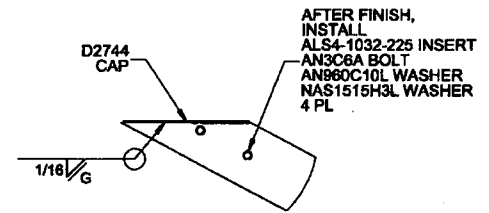
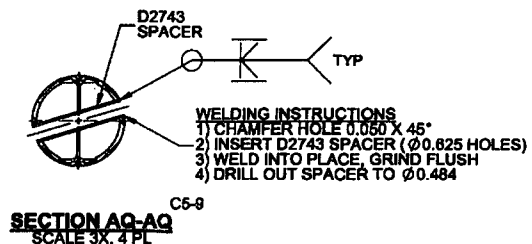
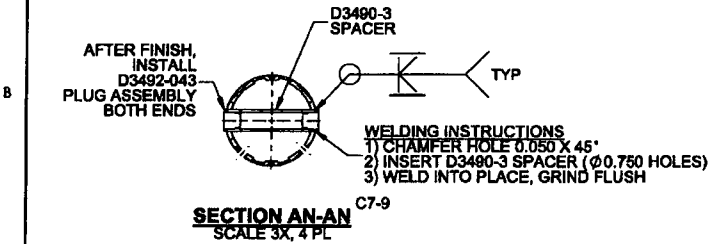


8 7 6 5 4 3 2 1



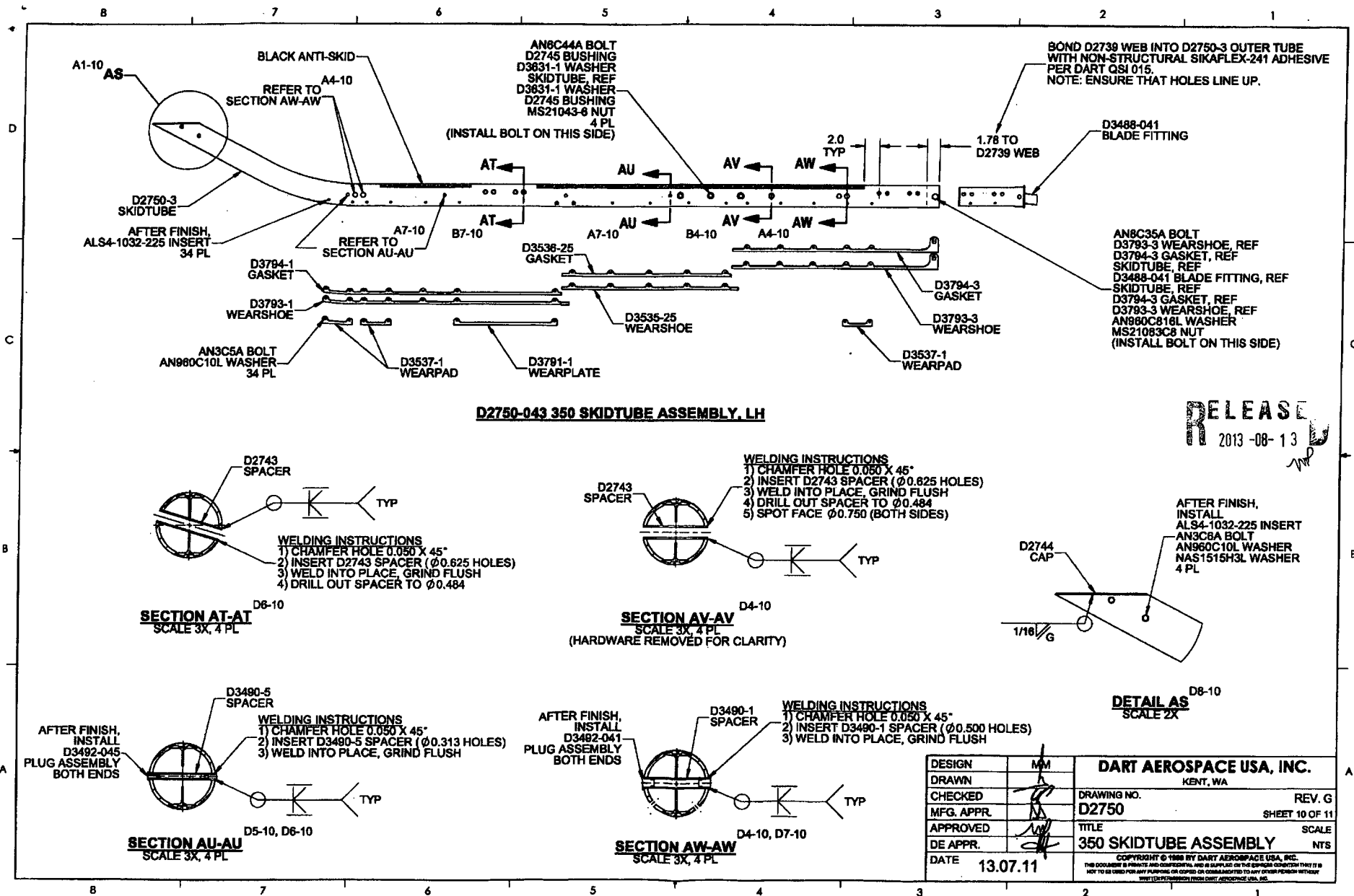
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13

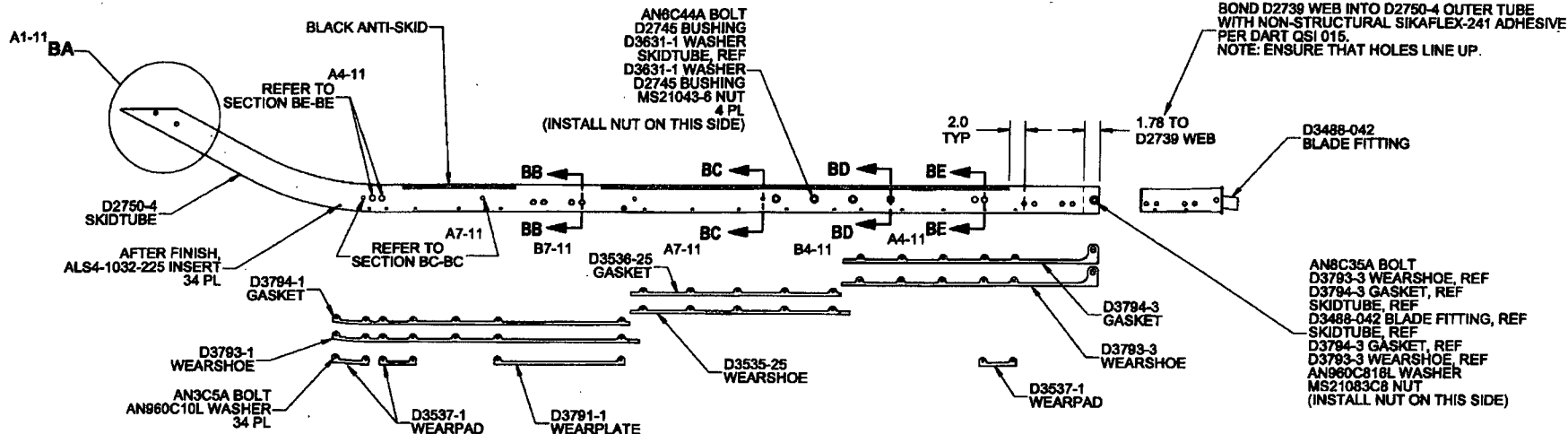


DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1996 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

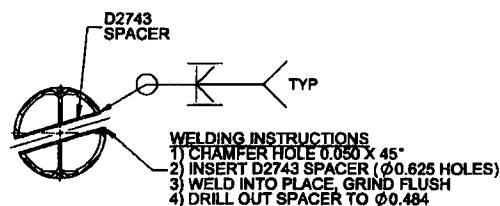
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



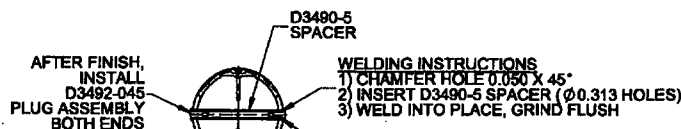
D2750-044 350 SKIDTUBE ASSEMBLY, RH



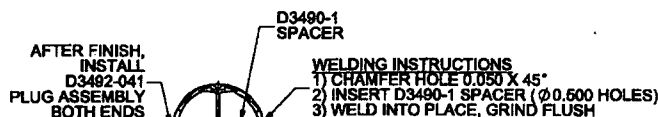
SECTION BB-BB
SCALE 3X, 4 PL



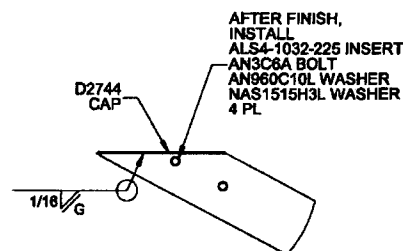
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1